

Work Order ID 142210

Wednesday, March 02, 2016 11:43:02 AM

142210

Page 1

Item ID: PB67-43001-51 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Long T-Handle Assembly
Start Date: 3/7/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 3/11/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: MLJ Date: MAR 02 2016 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-51	C

100 Weld per dwg A/R Aluminum rod Batch: 131562 0.00 DAS
24
9-89
100 Large Fab / MAR 04 2016

Large Fab Memo 0.01
1- drill #40 hole in center of -91 before welding -93 caps, to let air out
2- weld -93 to -91 as per dwg
3- grind weld flush
4- assemble -87 under the pilot hole in -91 and weld as per dwg

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 DAS
9
9-89
110 QC Memo 0.01 ① 16-03-10

Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00 DAS
9
9-89
120 QC Memo 0.01 ① 16-03-10

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Item ID: PB67-43001-51

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long T-Handle Assembly

Start Date: 3/7/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/11/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- line drill -89 and -87 using existing pilot hole of -87 as per dwg 2- install spring pin								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Green Sandtex (Ref: 4.3 5.8) per OSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	***mask prior to powder coat per dwg*** START TIME: 11:30 OVEN TEMPERATURE: 320° FINISH TIME: 12:00								

MAR 04 2016

DAS
24
9-89

① 16-03-10

DAS
9
9-89

1 16-03-01

238

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				1			38 9-89 MAR 22 2016
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>MEZZ2</u>	0.00				1			DAS 24 9-89 MAR 22 2016
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MCS MAR 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Wednesday, March 02, 2016 11:43:06 AM

Page 1

Work Order ID: 142210

142210

Parent Item: PB67-43001-51

PR67-43001-51

Parent Item Name: Long T-Handle Assembly

Start Date: 3/7/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-87		Manufactured	No			100	Each	3.0000	1	1			DAS
PR67-43001-87									**			MAR 04 2016	24 9-00
Tube Arm													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				3					
				140935				3					
PB67-43001-91		Manufactured	No			100	Each	3.0000	1	1			DAS
PR67-43001-91									**			MAR 04 2016	24 9-00
Tube Handle													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				3					
				133692				3					
PB67-43001-93		Manufactured	No			100	Each	6.0000	2	2			DAS
PR67-43001-93									**			MAR 04 2016	24 9-00
Tube End Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				6					
				133693				6					
240-107		Purchased	No			130	Each	81.0000	1	1			DAS
240-107									**			MAR 04 2016	24 9-00
SPRING SLOTTED PIN													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST568				81					
				m132006				81					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

Picklist Print

Page 2

Wednesday, March 02, 2016 11:43:06 AM

Work Order ID: 142210

142210

Parent Item: PB67-43001-51

PB67-43001-51

Parent Item Name: Long T-Handle Assembly

Start Date: 3/7/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-89

Manufactured No

130

Each

1.0000

1

1

PB67-43001-89

MAR 04 2016

**DAS
24
9-89**

Clevis

Location

Loc Qty

Loc Code

Mezz2

1

133544

1

DQA: _____ Date: _____



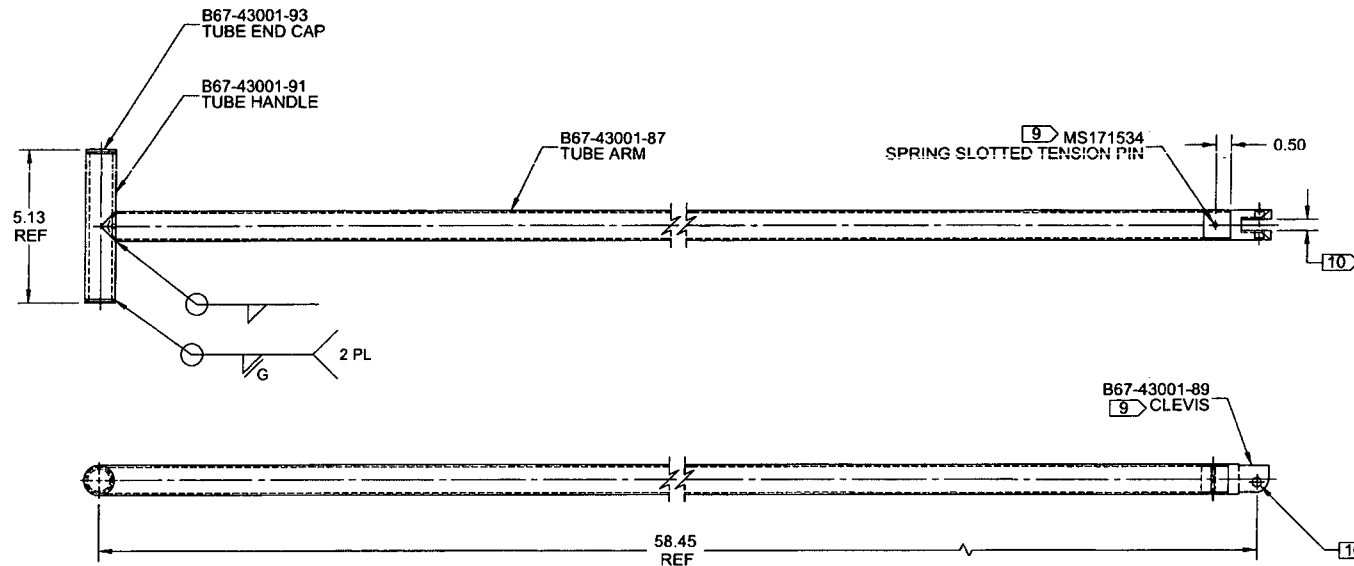
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

ITEM	QTY -19	P/N	DESCRIPTION
1	X	B67-43001-51	LONG T-HANDLE ASSY
3	1	B67-43001-87	TUBE ARM
4	1	B67-43001-89	CLEVIS
5	1	B67-43001-91	TUBE HANDLE
6	2	B67-43001-93	TUBE END CAP
8	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)



B67-43001-51 LONG T-HANDLE ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 142210 MJS
160302

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.35 lbs
- 8) WELDING: PER QSI 004
- 9) PRIOR TO POWDER COAT, ALIGN B67-43001-89 ON B67-43001-87 AS SHOWN AND DRILL A $\varnothing 0.129$ HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-89 TO B67-43001-87 USING MS171534 SPRING SLOTTED PIN
- 10) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN			
CHECKED	ADS		
MFG. APPR.	AB		
APPROVED	AN		
DE APPR.	N/A		
DATE	09.06.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-51** REV. C
SHEET 1 OF 1

TITLE **LONG T-HANDLE ASSY** SCALE NTS

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